

Date: Friday, 16/05/2008 8:45:48 AM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: FITTING
Job Number	: 39320	Part Number	: D31981
Estimate Number	: 10416	Drawing Number	: D3198 REV A
P.O. Number	:	Project Number	: N/A
This Issue	: 16/05/2008 S.O. No. : ,	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SMALL /MED FAB	Due Date	: 06/06/2008 Qty: 20 Um: Each
Previous Run	: 35282		
Written By	:		
Checked & Approved By	: <u>JUL 08.5.16</u>		
Comment	: Est: A 03.11.11 New Issue KJ/RF Est Rev:B Now on Waterjet 07-01-09 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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3.5



Comment: Qty.: 0.1103 sf(s)/Unit Total: 2.2050 sf(s)

304/316 .125 Sheet

Batch: 104934 B 8-5-21

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D3198

Dwg Rev: AProg Rev: AB 8-5-21

(27)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--

B 8-5-21

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/05/26 (27)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/05/26 (27)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Deburr if necessary

2-Form as per Dwg D3198

→ 08/05/26 (27) Hm
 SN 08/05/28 (27)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 16/05/2008 8:45:48 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 39320

Part Number: D31981

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/05/28 (27) counted

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

10:00

OVEN TEMPERATURE:

320°

FINISH TIME:

10:50

FL 08/05/29 (27)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BR 08-05-29 (27)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

P-80/30 (27)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/03

Job Completion



08-06-03

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

1.05.2

☒ **First Article** ☐ **Prototype**

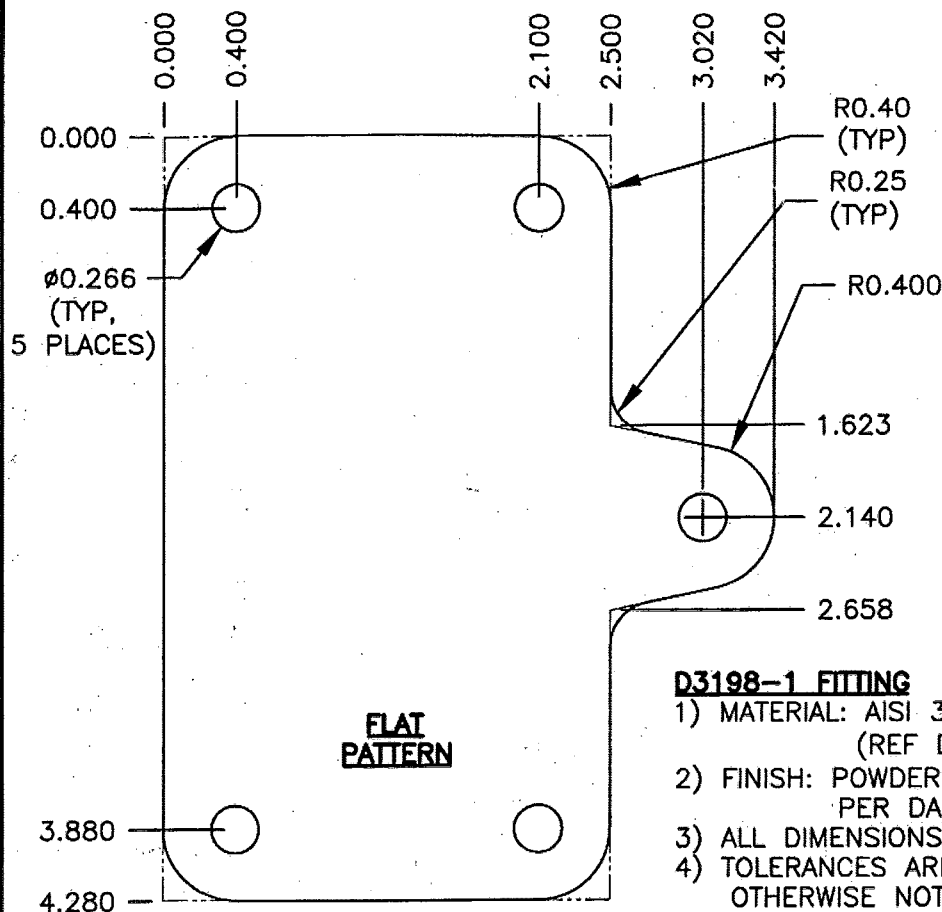
A handwritten lowercase letter 'f' is shown on a four-line grid. The letter starts at the top line, goes down to the bottom line, and has a short horizontal stroke at the top line level.

Prototype Approval:	N/A
Date:	N/A

[Signature]



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D3198	REV. A SHEET 1 OF 1
DATE 03.09.26	TITLE FITTING		SCALE 1:1
A	03.09.26	NEW ISSUE	

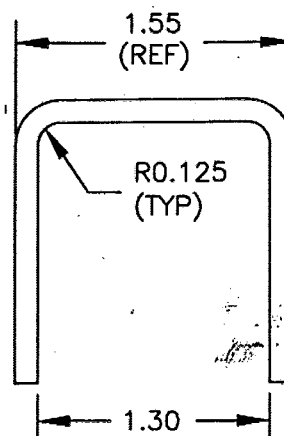
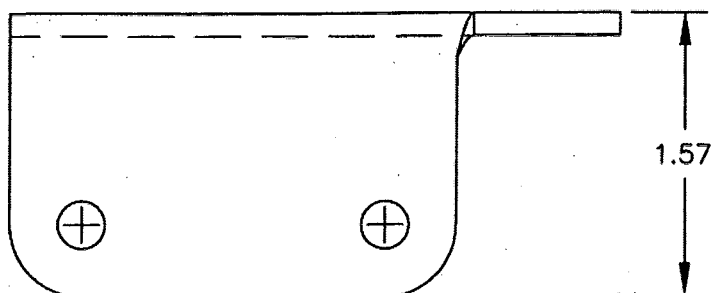


SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39320

D3198-1 FITTING

- 1) MATERIAL: AISI 304/316 SS SHEET 0.125 THICK
(REF DART SPEC. M304S11GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6)
PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

RELEASED
03.10.10



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